

Work Order ID 130169

February-25-15 12:43:33 PM

130169

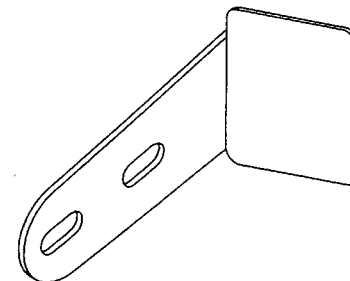
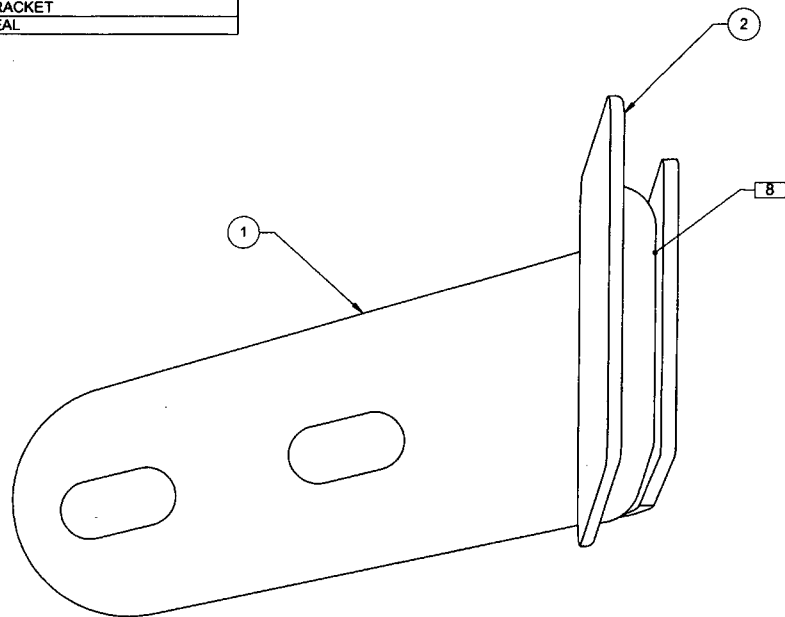
Page 2

Item ID: D3152-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seal
 Start Date: 2/25/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(6)			DAS 38 9-89
									MAR 17 2015
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>57A</u> Memo	0.00 0.00			DAS 30 9-89	6			15/03/25
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							15/3/27 JF ME 15-3-28

ITEM	QTY	P/N	DESCRIPTION
	X	D3152-041	BRACKET ASSY
1	1	D3152-1	BRACKET
2	1	D3152-3	SEAL



2/10/30169

D3152-041 BRACKET ASSEMBLY

RELEASED

2015 FEB 13
ECN 14-463 42

NOTES:

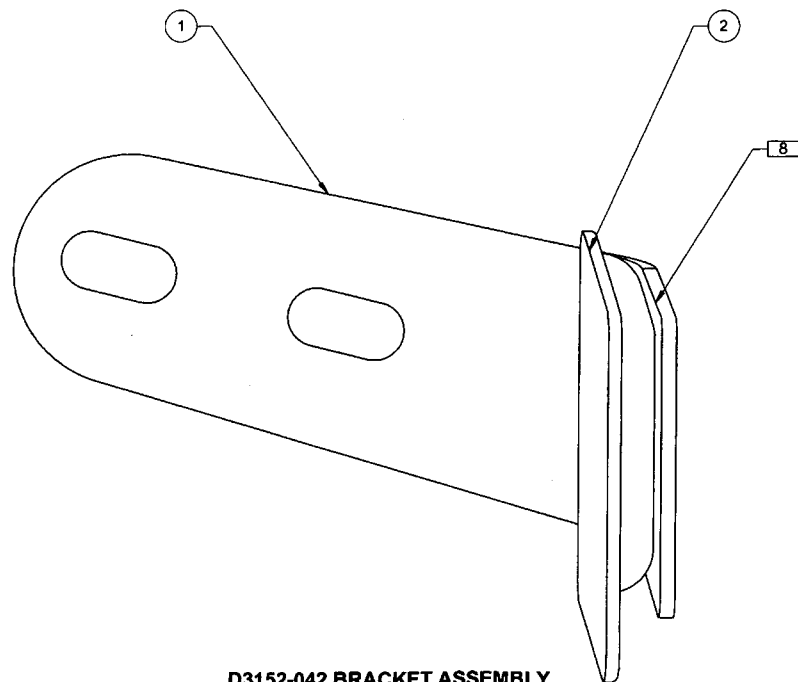
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-3 SEAL TO D3152-1 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

C	REVISE D3152-3/4 (MATERIAL), RE-FORMAT DRAWING, RE-DIMENSION D3152-1F	DB	14.10.28
B	ADD PART MARKING & RTV 732 BLACK	RF	04.10.18
A	NEW ISSUE	HS	02.04.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D3152	
MFG. APPR.	JLM		
APPROVED	HS	TITLE BRACKET ASSEMBLY	
DE APPR.	DS		
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APPROVED

REV. C
SHEET 1 OF 5
SCALE
NTS

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3152-042	BRACKET ASSY
1	1	D3152-2	BRACKET
2	1	D3152-4	SEAL



D3152-042 BRACKET ASSEMBLY

RELEASED

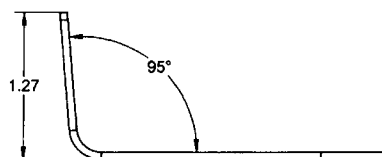
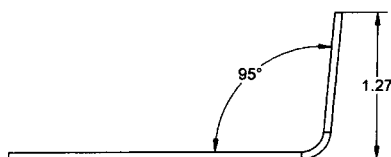
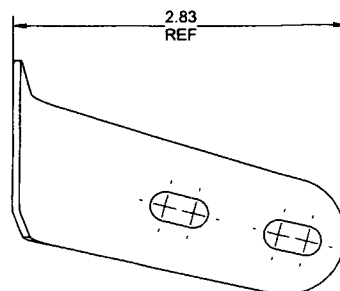
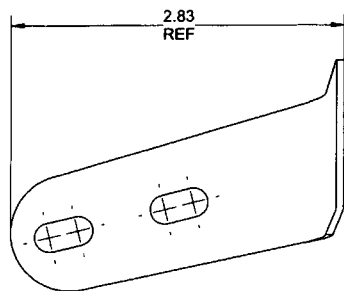
2015 FEB 13 *q*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-4 SEAL TO D3152-2 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

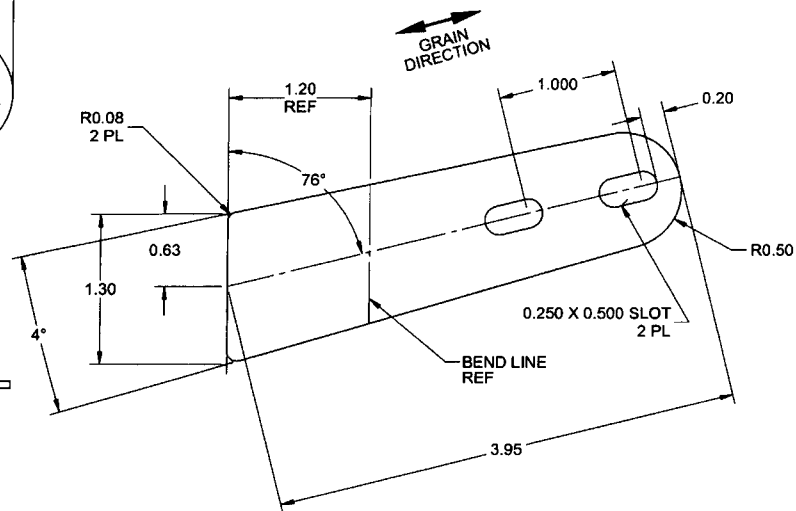
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DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D3152-1 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-223)

D3152-2 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-224)



D3152-1F BRACKET
(FLAT PATTERN)

RELEASED

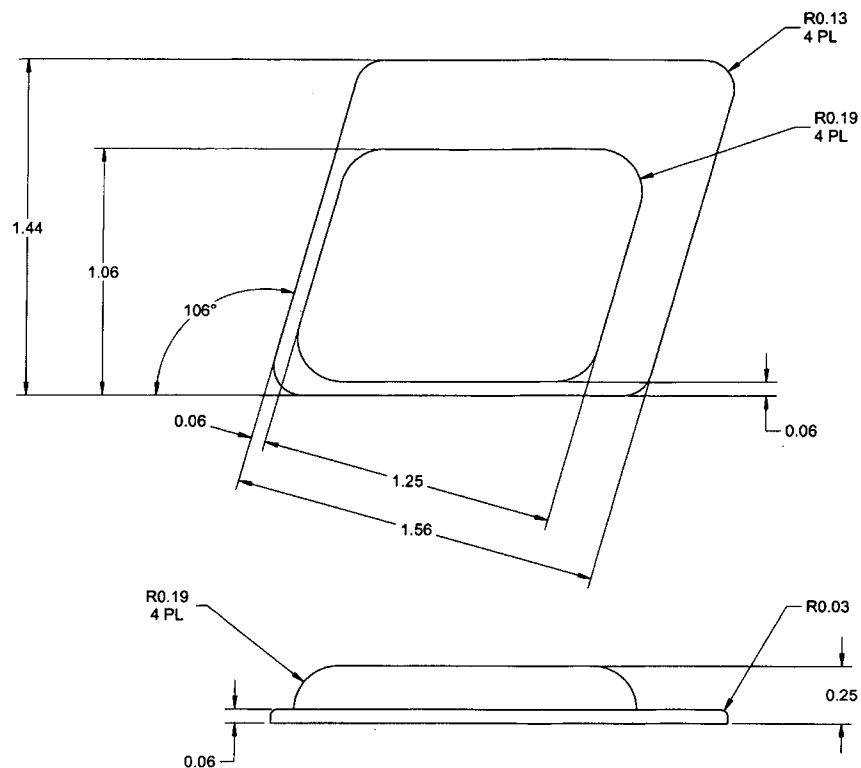
2015 FEB 13

NOTES:

- 1) MATERIAL: D3152-1F: 2024-T3 ALUMINIUM SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 PER DART SPEC M2024T3S 063
- 2) FINISH: D3152-1/-2: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D3152-3 SEAL
(REPLACES PREMIER P/N B30-23000-243)

RELEASED

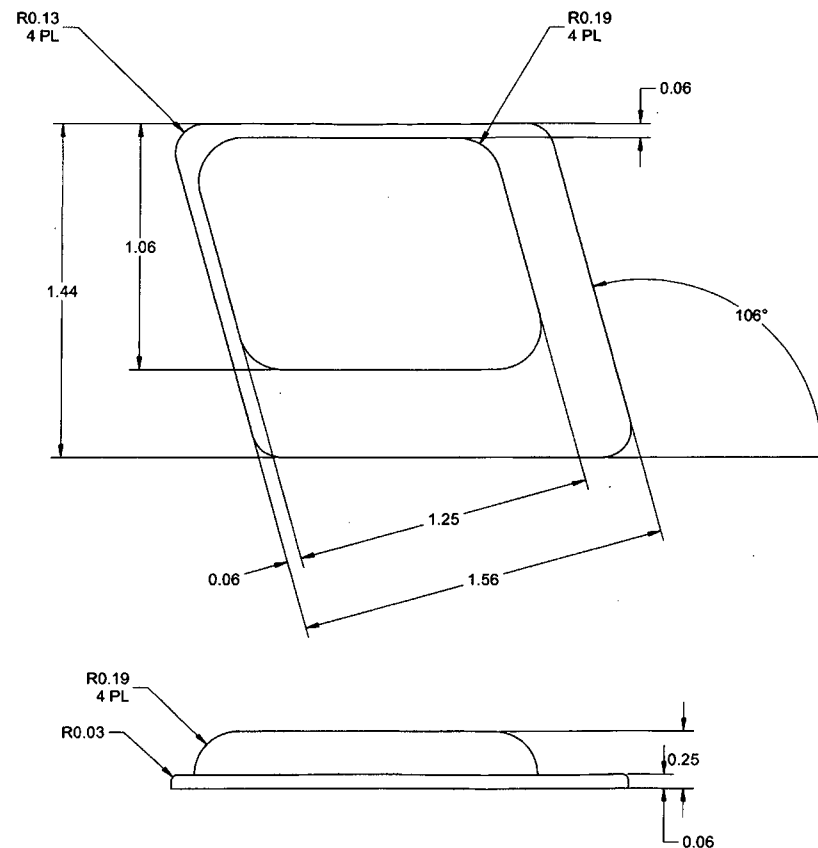
2015 FEB 13 *4P*

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D3152-4 SEAL
(REPLACES PREMIER P/N B30-23000-244)

RELEASED

2015 FEB 13

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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DART AEROSPACE LTD	Work Order:	130169
Description: Seal	Part Number:	D3152-3
Inspection Dwg: D3152-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

NOT APPLICABLE

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.44	± .030"	1.44"	✓			
1.06	"	1.06"	✓			
1.25	"	1.25"	✓			
1.56	"	1.55"	✓			
0.06	"	0.06"	✓			
0.25	"	0.249"	✓			

Measured by:	Wh	Date:	15/03/26
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Audited by:	DAS 39	Date:	MAR 26 2015
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Preliminary Approval:	G.H.	Date:	
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	